

Date: Thursday, 4/12/2007 8:21:35 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG BRACKET
Job Number : 31652	
Estimate Number : 10364	
P.O. Number : <i>N/A</i>	Part Number : D3046041
This Issue : 4/12/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3046 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 31380	Material : <i>N/A</i>
Written By : _____	Due Date : 4/30/2007 Qty: <i>29</i> Um: Each
Checked & Approved By : <i>07.04.12</i>	
Comment : Est: A 01.08.27 New issue SM/EC	
est: B 06.11.30 Per revB, EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D30461	Lug Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
 LUG BRACKET

Qty	Part Number	Description	Batch
1	D3046-1	Lug Bracket	<i>31160</i>

FC

2.0	D30465	HOOK
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
 LUG

Pick:

Qty	Part Number	Description	Batch
1	D3046-5	Lug	<i>B31229 x9</i>

*B31095 x20**FC*

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1
 Weld assembly as per dwg D3046

*FC**07/04/19**(29)*

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

02/04/19 (29)

5.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

07/04/19 (29)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: P Date: 09/04/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:21:35 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 31652

Part Number: D3046041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

OUTSIDE SERV.20

OUTSIDE SERVICE - SF



Comment: Sub-Contracting PURCHASING

Issue P/O: 3592

Heat treat Ass'y as per Dwg D3046

(Heat treat ass'y to H900 hardened condition min 190 KSI)

Possible Supplier: Vac-aero

Certificate of conformity required

CL 07/04/19

(29)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

PO 7/4/25

(29)

8.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Ensure certificate of conformity comply to Dwg D3046

U 07-04-26

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

ESD 07-04-26 (29)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

ESD 07/04/27 (29)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ESD 07/04/27 (29)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

ESD 07/04/30 (29)

Job Completion



U 07-04-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

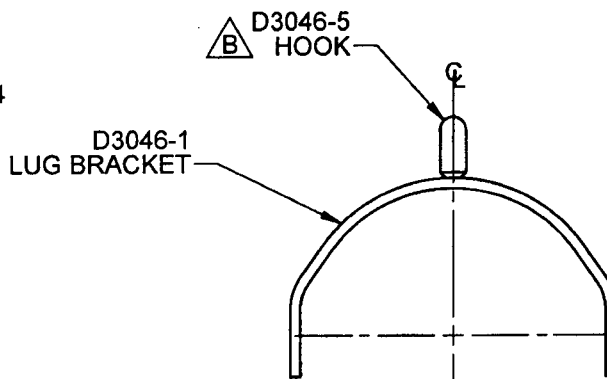
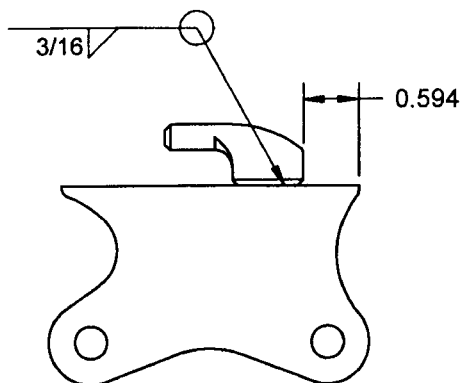
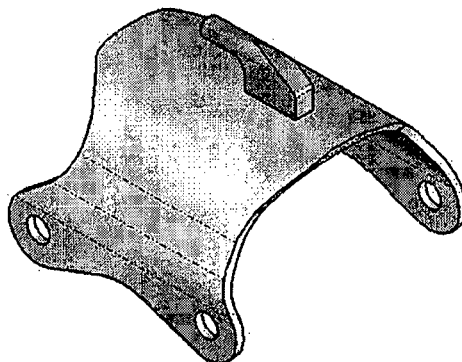
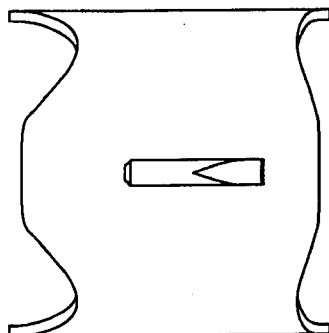
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3046	REV. B SHEET 1 OF 3
DATE 06.10.26		TITLE LUG BRACKET ASSEMBLY SCALE 1:2	
REV	DATE	DESCRIPTION	
A	01.08.23	NEW ISSUE	
B	06.10.26	ADD D3046-5 REMOVE D3046-3; INCREASE HOLE DIAMETER OF D3046-1; CHANGE MATERIAL TO 17-4PH FROM 1010 STEEL	

RELEASED
06.11.13 [Signature]



D3046-041 LUG BRACKET ASSEMBLY

QTY	P/N	DESCRIPTION
X	D3046-041	GROUND HANDLING LUG ASSEMBLY
1	D3046-1	LUG BRACKET
1	D3046-5	HOOK



NOTES:

- 1) FINISH: HEAT TREAT ASSEMBLY TO H900 HARDENED CONDITION (MIN 190 KSI)
POWDER COAT ASSEMBLY WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) WELD PER DART QSI 004
- 5) PART IS SYMMETRICAL ABOUT C
- 6) IDENTIFY WITH P/N D3046-041 USING FINE POINT PERMANENT INK MARKER

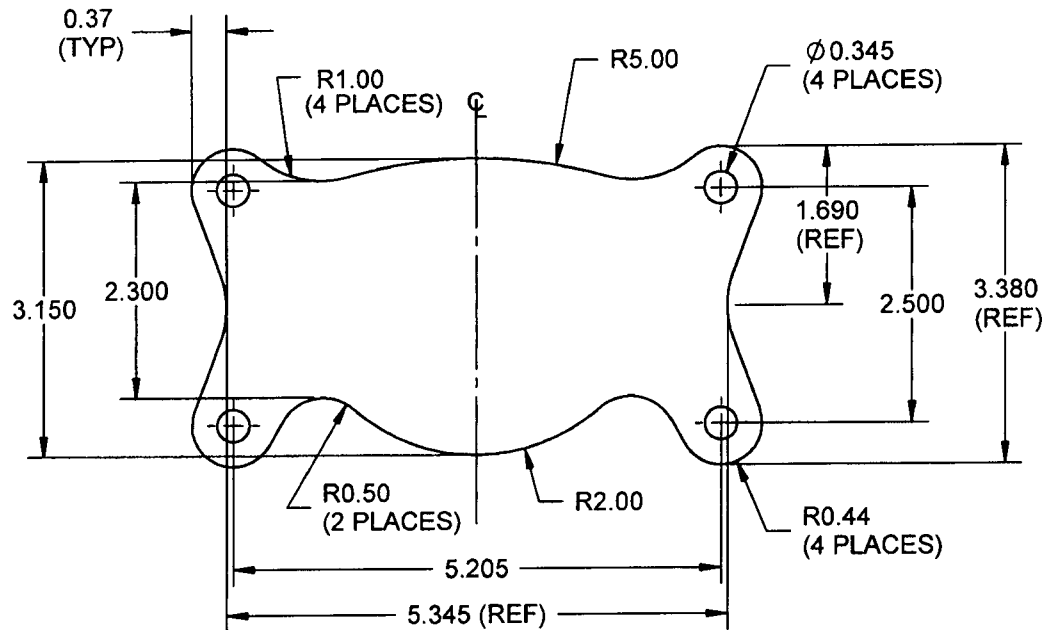
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WORK ORDER
NO. **31652**

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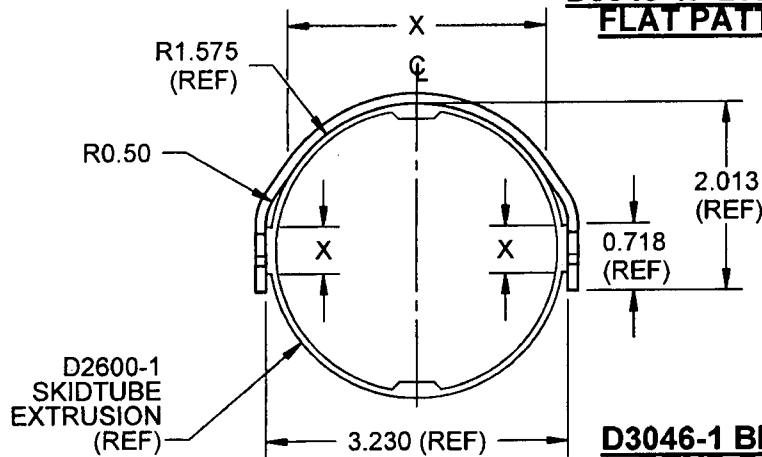
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DART

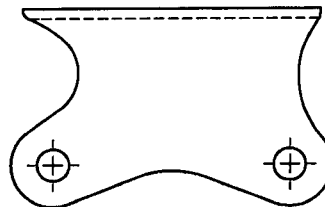
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CHECKED #	APPROVED #	DRAWING NO. D3046	REV. B SHEET 2 OF 3
DATE 06.10.26	TITLE LUG BRACKET ASSEMBLY		SCALE 1:2



**D3046-1F BRACKET
FLAT PATTERN**



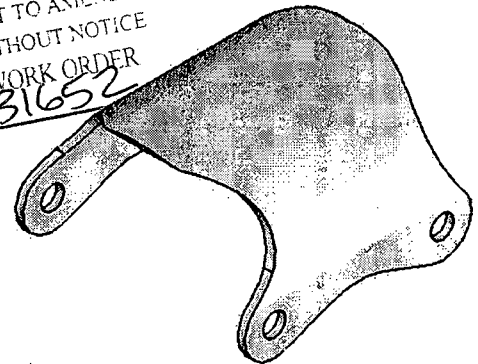
**D3046-1 BRACKET
BEND DETAIL**



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NO. 31652

NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL SHEET, 0.109" THICK (12 GAUGE) PER AMS 5604 (REF DART SPEC M17-4-S12GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) D3046-1 SHOULD BE BENT USING DT8351 TOOL SO THAT IT IS WITHIN 0.010" OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X'.



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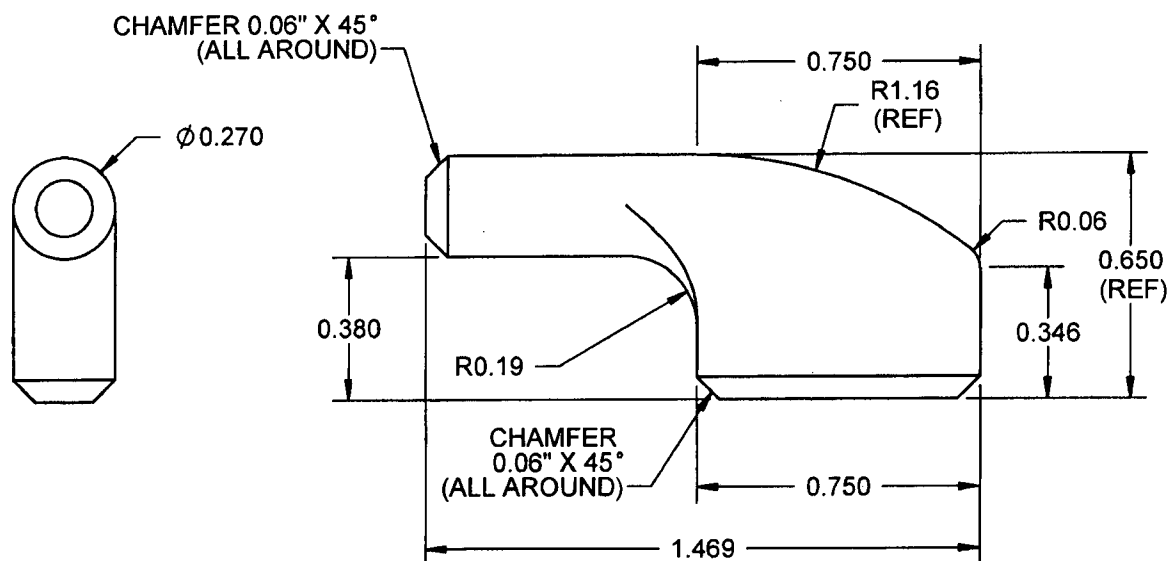
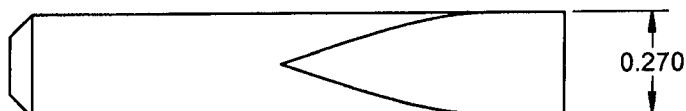
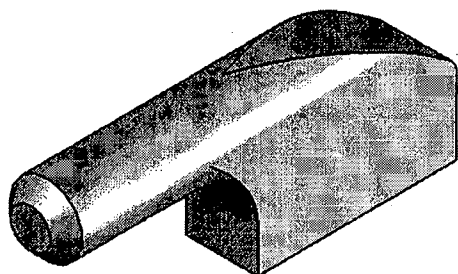
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CHECKED JH	APPROVED JH	DRAWING NO. D3046	REV. B SHEET 3 OF 3
DATE 06.10.26		TITLE LUG BRACKET ASSEMBLY	SCALE 2:1

RELEASED

06.11.13

**D3046-5 HOOK** **NOTES:**

- 1) MATERIAL: 17-4PH STAINLESS STEEL BAR PER AMS 5604 OR AMS 5643 (REF DART SPEC. M17-4-B)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

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VAC AERO
INTERNATIONAL INC.

PACKING SLIP

OAK 86566-1



HEAD OFFICE
1371 SPEERS ROAD, OAKVILLE, ONTARIO
CANADA L6L 2X5
TEL: (905) 827-4171 FAX: (905) 827-7489



QUEBEC DIVISION
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CANADA H4S 1C5
TEL: (514) 334-4240 FAX: (514) 334-6269

GST No.: R105468102

04/24/2007

MM / DD / YYYY

PAGE: 1

BILL TO: 1DAR01
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

SHIP TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
04/24/2007	PUROLATOR# 7684382	ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
3592		COD

LN	PART NO	DESCRIPTION	UOM	QTY ORDERED	QTY SHIPPED	B/O QTY
01	D3046	-041	EA	49	49	0
		Process Specifications: Procedure: 3806 HEAT TREATED TO H900 PER AMS 2759-3D 100% HARDNESS CHECKED AS PER ASTM E-18 HRC: 40-47 MATERIAL: 17-4 20 PCS B31214 29 PCS B31652				
02	MC	MINIMUM CHARGE		1	1	0

No claims for shortage in weight or count will be entertained, unless presented within 5 working days after receipt of materials by customer.



VACUUM BRAZING - HEAT TREATING - SPECIAL PROCESSING - FURNACE EQUIPMENT
TURBINE COMPONENT OVERHAUL - PLASMA AND OTHER COATINGS





VAC AERO
INTERNATIONAL INC.

RELEASE NOTE

GST No. : R105468102

OAK 86566-1

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04/24/2007

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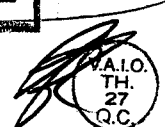
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1270 ABERDEEN ST.
HAWKESBURY, ON

SHIP TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
04/24/2007	PUROLATOR# 7684392	ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
3592		COD

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
D3046	-041	EA	49	49	
<p>Process Specifications: Procedure: 3806 HEAT TREATED TO H900 PER AMS 2759-3D 100% HARDNESS CHECKED AS PER ASTM E-18 HRC: 40-47 MATERIAL: 17-4</p> <p>20 PCS B31214 29 PCS B31652</p> <div style="border: 2px solid black; padding: 5px; display: inline-block;">100% HARDNESS TESTED <i>49 PCS → 42/43 HRC</i></div> <div style="text-align: right;"> </div>					

I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.

Authorized Q.C. Inspector



VACUUM BRAZING · HEAT TREATING · SPECIAL PROCESSING · FURNACE EQUIPMENT
TURBINE COMPONENT OVERHAUL · PLASMA AND OTHER COATINGS

